

Date: Monday, 23/03/2009 9:53:09 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CLEVIS
Job Number :	46634		
Estimate Number :	10104		
P.O. Number :		Part Number :	D2012107
This Issue :	23/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2012-107 REV. C
First Issue :	/ /	Project Number :	N/A
Previous Run :	45074	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :	<u>J.D. 09.03.23</u>	Due Date :	10/04/2009
Comment :	Est: D 01.11.08 Re-format, Drawing to Rev. C SM Est Rev:E Now on Waterjet 06-06-13 JLM		

Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.0168 sf(s)/Unit Total : 0.6720 sf(s)
 304/316 .063 Sheet
 (M304S063)
 Batch: 111323 B 9-4-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2012-107
 Dwg Rev: C
 Prog Rev: C

B 9-4-20

(48)

2-Deburr if necessary B 9-4-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-4-20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/04/20 counter x48

5.0	BRAKE NC	NC BRAKE
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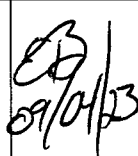

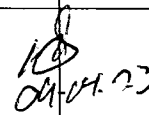
Comment: NC BRAKE
 Form on press using DT8242 as per Dwg D2012-107

Ep 09/04/23

(Ph) →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2012-107 PAR #: N/A Fault Category: Prod lineassy med & small NCR: (Yes) No DQA: D Date: 09/04/20
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/04/20

NCR: <u>46634</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/23	5.0	2 parts scrap. they were not positioned correctly in sig causing Parts to be "cracked"		Scrap and Destroy Qty <u>(2)</u> no replace	 09/04/23	S 09/04/23		 09/04/23
		N.C. Human error LACK of Attention.						

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 9:53:10 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 46634

Part Number: D2012107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

Sorted 23

(X46)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST8

Sorted 09/04/23

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mtf 09-04-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

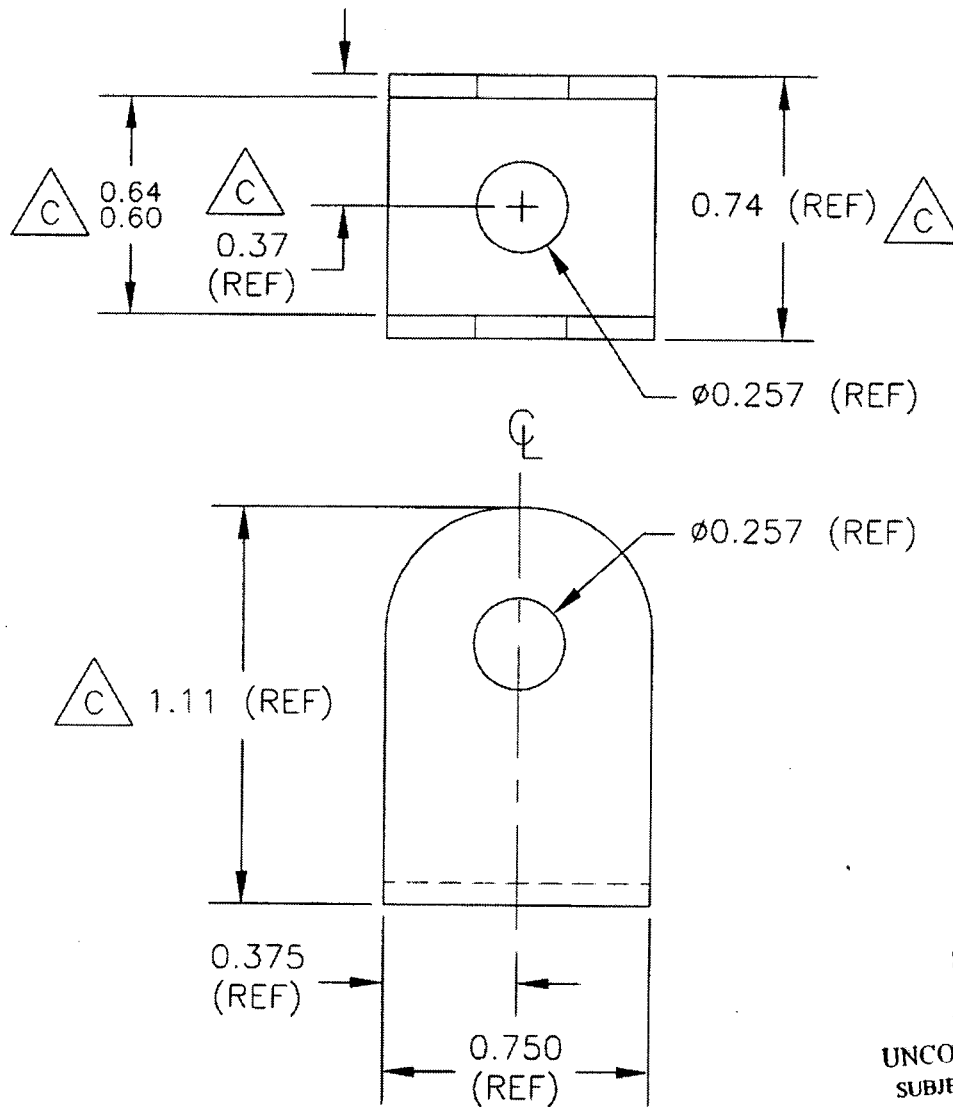
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 1 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	99.04.30	ADD FLAT PATTERN	
C	99.12.20	0.74 WAS 0.680	

RELEASED
CO. 01 04 DS



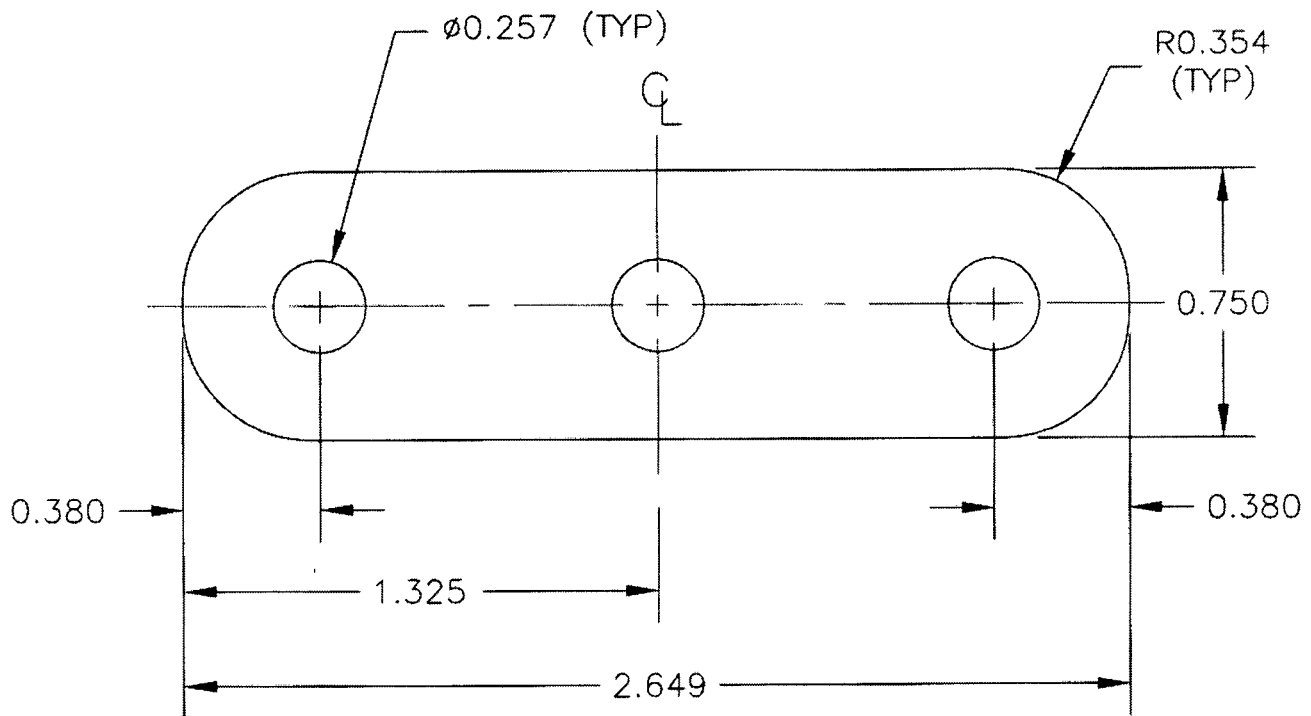
MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40034



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1

RELEASED
00 01 04 DS



D2012-107 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No. 116034

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES